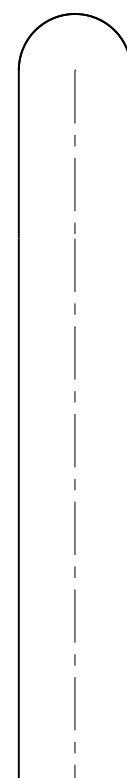
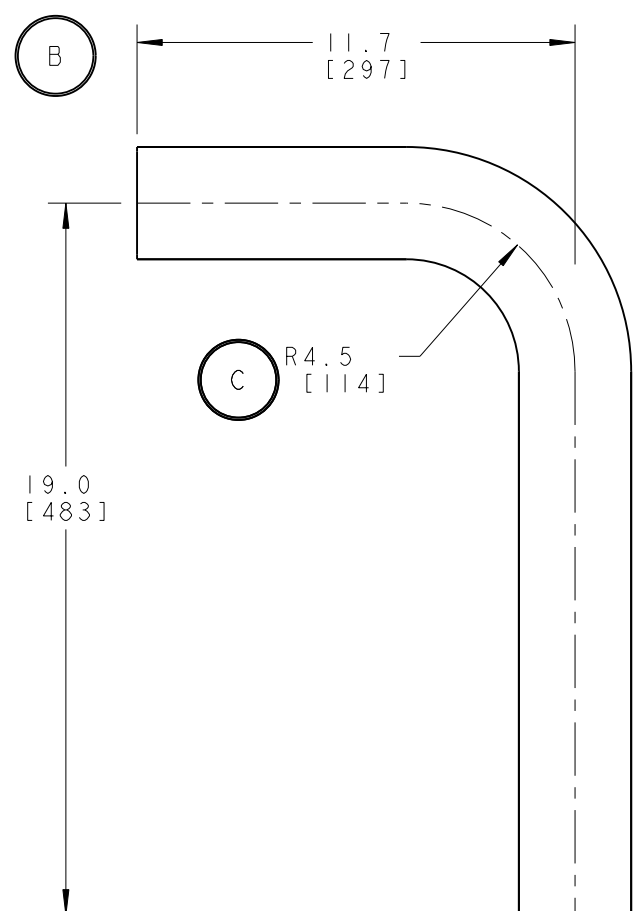


DESCRIPTION	QUANTITY	UNIT	PRICE	TOTAL
TUBE, PER ASTM				

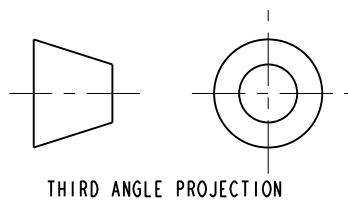
[illegible]

1. THIS IS A CRYOGENIC VACUUM COMPONENT.
2. WELDING PROCEDURE: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
3. CLEANING PROCEDURE : PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
4. PACKAGING AND STORAGE PROCEDURE OF THE COMPONENTS:  
PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
5. DIMENSIONS AND TOLERANCING PER ANSI Y14.5M-1982.  
UNITS ARE IN INCHES [mm] UNLESS OTHERWISE SPECIFIED.
6. USE OF SULFUR OR SILICONE BEARING OILS, LUBRICANTS,  
OR COOLANTS ARE STRICTLY PROHIBITED.
7. USE OF RESIN OR RUBBER BONDED ABRASIVES UNDER POWER  
IS STRICTLY PROHIBITED. USE VITREOUS BONDED ABRASIVES  
ONLY.
8. VENDOR SUGGESTED CHANGES TO WELD PREPS; SUBJECT TO  
LBNL APPROVAL.
9. FITTINGS MAY BE USED IN PLACE OF BENDS; SUBJECT TO LBNL APPROVAL.
10. VENDOR SUGGESTED CHANGES TO TOLERANCES TO FACILITATE  
FABRICATION OR ASSEMBLY; SUBJECT TO LBNL APPROVAL.
11. REMOVE ALL THE BURRS AND REAM THE ENDS FOR CIRCULARITY  
AND CLEAN ENDS.
12. TUBE END SURFACE MUST BE PERPENDICULAR TO THE TUBE AXIS  
WITHIN  $\pm .010$ .
13. PERFORM ACCEPTANCE TESTS PER LBNL SPECIFICATION M989.



— Ø3.000 [76.2] TUBE X  
.065 [1.65] WALL


SCALE 5 / 16



C	RLM	JER	6/9/03	TUBE WALL THK FROM .079 TO .065, BEND RADIUS TO ACCOMMODATE 90° ELBOW, SUCH AS MDC #403512.	
B	ARH	SPV	01/13/03	DRAWING DIM 11.7 WAS 13.0	
A	ARH	SPV	11-01-02	INITIAL RELEASE	
REV	DWG	CHK	ZONE	DATE	CHANGES

UNLESS OTHERWISE SPECIFIED	
TOLERANCES	
X.X ± 0.1	FRAC. ± 1/64
X.XX ± 0.03	Angles ± 1.00°
X.XXX ± 0.010	FINISH 125 $\sqrt{R_a}$
DO NOT SCALE PRINT	
THREADS ARE CLASS 2	
CHAMFER ENDS OF ALL SCREW THREADS 30°	
CUT ROUND, 1.5 THREAD RELIEF ON MACHINED THREAD	
BREAK EDGES .016 MAX. ON MACHINED WORK	
REMOVE BURRS, WELD SPATTER AND LOOSE SCALE	
IN ACCORDANCE WITH ASME Y14.5M & B46.1	

SHOP ORDERS		SER	NO
ACCT NO	NO	DATE	
REGO	REGO	1550	
REL TO	DATE	REGO	
SURFACE TREATMENT			
IDENT METHOD	TAG		
PROJECT NUMBER	N/A		
PROJECT NAME	N/A		
DWS BY KNOLLS		DATE	13-Aug-01
CHK BY	Jon Zbosnik, S. Virostek	DATE	29-Oct-02
APPR BY	Jon Zbosnik/D. Oshatz	DATE	29-Oct-02

<b>ERNEST ORLANDO LAWRENCE</b> <b>BERKELEY NATIONAL LABORATORY</b> UNIVERSITY OF CALIFORNIA - BERKELEY				
LHC IR FEEDBOX CRYOGENICS PIPE, XB, SURGE TANK ATTACHMENT				
MICROFILMED:	DWG. TYPE <b>PART</b>	SHOWN ON -	SCALE: <b>5/16</b>	DO NOT SCALE PRINTS
PATENT CLEAR: DESIGN ACCT. NO. <b>Z5LCE2</b> CATEGORY CODE <b>LH2003</b>			DWG. NO. <b>2515494</b>	SIZE <b>REV.</b>

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